

Work Order ID 128690

128690

Page 1

Thursday, January 22, 2015 10:25:40 AM

Item ID: D206-642-441 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Replacement Skidtube, High Gear with Standard Wearplates Fits LH or RH

Start Date: 1/26/15 Start Qty: 1.00 *1* Cust Item ID:

Required Date: 1/30/15 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan:  Date: 1-1-22 Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2650	Rev F(DEO)

100	Document Control	0.00
100	DOCUMENT CONTROL	
DC	Memo	0.00
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D206-642-441	CHG005

N/A ML5 1503-23

Work Order ID 128690

Thursday, January 22, 2015 10:25:40 AM

128690

Page 2

Item ID: D206-642-441 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Replacement Skidtube, High Gear with Standard Wearplates Fits LH or RH
Start Date: 1/26/15 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 1/30/15 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

110

Skidtubes

Skidtubes

Skidtubes

Memo

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/RAluminum Rod *130837/m 130812*

4-Grind weld flush to cap on top surface only.

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open aft cap holes using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail

12-Deburr and Blow out all chips form inside the tube

*DGC 15-1-27**130837/m 130812*
*DGC 15-1-28**DGC 15-1-29*

Work Order ID 128690

128690

Page 3

Thursday, January 22, 2015 10:25:40 AM

Item ID: D206-642-441

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube, High Gear with Standard Wearplates Fits LH or RH

Start Date: 1/26/15 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 1/30/15 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

115

QC5- Inspect part completeness to step on W/O

0.00

115

QC

Memo

0.00

Quality Control

DAS
03
9-89

15-2-2

116

QC10- Inspect visual per QSI004- ground welds

0.00

116

QC

Memo

0.00

Quality Control

DAS
9
9-89

15-2-2

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

15-2-2



Work Order ID 128690

Thursday, January 22, 2015 10:25:40 AM

128690

Page 4

Item ID: D206-642-441 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Skidtube, High Gear with Standard Wearplates Fits LH or RH
 Start Date: 1/26/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/30/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 QC7-Inspect Chemical Conversion Coat 0.00

130

QC Memo 0.00

Quality Control

DAS
03
9-89

[Signature] 15-2-2

140 Skidtubes 0.00

140

Skidtubes Memo 0.00

Skidtubes 1-Bond D2654-7 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs. cure time before cutting

Start Date: 4:00 pm
 Time: _____

Finish Date: _____
 Time: _____

A/RSikaflex-291 131120
 Sikaflex expiry date: 15-10-21

[Signature] 15-2-2

Work Order ID 128690

128690

Page 5

Thursday, January 22, 2015 10:25:40 AM

Item ID: D206-642-441 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Replacement Skidtube, High Gear with Standard Wearplates Fits LH or RH
 Start Date: 1/26/15 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 1/30/15 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00				1	0	15-02-03	L 16 9-89
150									DAS 18 8-89
QC	Memo	0.00							
Quality Control									
160		0.00				1	0	15-2-3	
160	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1- Insert D4720-1 Spacer. Swage to 0.313" X 0.75" DP per QSI 002. Trim and grind flush per QSI 002								
170		0.00				1	0	15-2-3	
170	HandFinishing								
Skidtubes	Memo	0.00							
Skidtubes	Install D2680-041 Nut Plate as per Dwg D2650								

Work Order ID 128690

128690

Page 6

Thursday, January 22, 2015 10:25:40 AM

Item ID: D206-642-441 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Replacement Skidtube, High Gear with Standard Wearplates Fits LH or RH
 Start Date: 1/26/15 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 1/30/15 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				1			DAS 38 9-89 15-02-10
200 *200* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.	0.00 0.00				1			15-2-20 [Signature]
210 *210* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum m 124808. Memo Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. START TIME: 8:25. OVEN TEMPERATURE: 320° FINISH TIME: 8:55.	0.00 0.00				1	0	15-8-12	DAS 34 9-89

Work Order ID 128690

128690

Page 7

Thursday, January 22, 2015 10:25:40 AM

Item ID: D206-642-441 Accept *N900040100* Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube, High Gear with Standard Wearplates Fits LH or RH

Start Date: 1/26/15 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 1/30/15 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220

QC3- Inspect Part Finish

0.00

220

QC

Memo

0.00

Quality Control

1x of 98 15103116

Work Order ID 128690***128690***

Page 8

Thursday, January 22, 2015 10:25:40 AM

Item ID: D206-642-441 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Replacement Skidtube, High Gear with Standard Wearplates Fits LH or RH
Start Date: 1/26/15 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 1/30/15 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
230	HandFinish	0.00							
Hand Finishing	Memo 1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. A/RSikaflex-291 <u>M1131574</u> Sikaflex expiry date: <u>13110</u> 2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive <u>R405981361K M125792 exp: 15105</u> 3-Install MS27039-4-06 Screw as per DEO 9153 4-Inspect for foreign object per QSI 024 5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive A/RSikaflex-291 <u>M1131574</u> Sikaflex expiry date: <u>13110</u> 6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4 Batch: <u>M131636</u>								

Work Order ID 128690

128690

Page 9

Thursday, January 22, 2015 10:25:40 AM

Item ID: D206-642-441

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube, High Gear with Standard Wearplates Fits LH or RH

Start Date: 1/26/15 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 1/30/15 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89

240

QC

Memo

0.00

Quality Control

15-03-18

250

250

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-441

Location: _____

PPP Rev: _____

PPD

DAS
36
9-89

MAR 23 2015

(2793)

260

260

QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

MCS 1503-23

ME

5.8.23

Picklist Print

Thursday, January 22, 2015 10:25:44 AM

Page 1

Work Order ID: 128690

128690

Parent Item: D206-642-441

D206-642-441

Parent Item Name: Replacement Skidtube, High Gear with Standard Wearplates Fits LH or RH

Start Date: 1/26/15

Required Date: 1/30/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H05.10.11 Added D3429-1 per CHG002 KJ/CP/JLM
IPP Rev:I 08-05-01 add QC3 DD verified by: EC
IPP Rev:J 08-09-29 revF as per dwg DD verified by: EC IPP rev K
10.09.27 SS washers for wearplates EC verf:DD IPP Rev:L 12.11.22 now
swage per ecn12-679 DD verf:JLM IPP REV:M 14.04.25 AS PER
ECN14-520 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4956-15		Manufactured	No				Each	26.0000		1			
D4956-15									**			15/03/17	
Wearplate Fwd													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP002				26					
				124078				13		✓			
				126458				13					
D4956-23		Manufactured	No				Each	19.0000		1			
D4956-23									**			15/03/17	
Wearplate Center Fwd													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP002				19					
				124079				8					
				126459				11		✓			
D4956-37		Manufactured	No				Each	5.0000		1			
D4956-37									**			15/03/17	
Wearplate Aft													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP002				5					
				119666				5		✓			

Picklist Print

Page 2

Thursday, January 22, 2015 10:25:44 AM

Work Order ID: 128690

128690

Parent Item: D206-642-441

D206-642-441

Parent Item Name: Replacement Skidtube, High Gear with Standard Wearplates Fits LH or RH

Start Date: 1/26/15

Required Date: 1/30/15

Start Qty: 1.00

Required Qty: 1.00

D2620	Manufactured	No	110	Each	13.0000	1	1
-------	--------------	----	-----	------	---------	---	---

D2620

Skidtube, 206 Skidtube

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

LG002	13	
126930	13	

D2647	Manufactured	No	110	Each	10.0000	1	1
-------	--------------	----	-----	------	---------	---	---

D2647

Cap

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

LG001	10	
114961	10	

D2654-7	Manufactured	No	140	Each	1.0000	1	1
---------	--------------	----	-----	------	--------	---	---

D2654-7

Web

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

LG002	1	
109327	1	

D4720-1	Manufactured	No	160	Each	358.0000	23	23
---------	--------------	----	-----	------	----------	----	----

D4720-1

Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

LG001	358	
114878	358	

DGL 15-1-27

8615-01-27

108145 x1 DGL 15-2-2

15-2-3

Thursday, January 22, 2015 10:25:45 AM

Shop Packet Print

Page 2

Picklist Print

Thursday, January 22, 2015 10:25:45 AM

Work Order ID: 128690

128690

Parent Item: D206-642-441

D206-642-441

Parent Item Name: Replacement Skidtube, High Gear with Standard Wearplates Fits LH or RH

Start Date: 1/26/15

Required Date: 1/30/15

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3 CCR264SS-3-03 Purchased No

170 Each

83.0000

2 2

CCR264SS3-3

Cherry Rivet

**

15-2-3 *[Signature]*

Location

Loc Qty

Loc Code

FP001

40

m126333

40

ST321

43

113973

23

m128818

20

D2680-041 Manufactured No

170 Each

21.0000

1 1

D2680-041

Nut Plate

**

15-2-3 *[Signature]*

Location

Loc Qty

Loc Code

LG001

21

115056

21

ALS4-1032-130 AELS4-1032-130 Purchased No

230 Each

3,327.000

60 60

AIS4-1032-130

Rivnut

**

11 15103116

Location

Loc Qty

Loc Code

CA

1617

M128649

1617

FP001

639

M128649

639

st549

1071

M128649

1071

X60

Picklist Print

Page 4

Thursday, January 22, 2015 10:25:46 AM

Work Order ID: 128690

128690

Parent Item: D206-642-441

D206-642-441

Parent Item Name: Replacement Skidtube, High Gear with Standard Wearplates Fits LH or RH

Start Date: 1/26/15

Required Date: 1/30/15

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

230

Each

807.0000

2

2

CR3212-4-03

Cherry Rivet

**

15-2-3

Location

Loc Qty

Loc Code

CCK004

700

119017

700

FP001

7

m123265

7

LG001

38

m123265

38

ST320

62

m114859

62

D2646

Manufactured

No

230

Each

16.0000

1

1

D2646

Aft Cap

**

15/03/14

Location

Loc Qty

Loc Code

FG

4

85848

2

90495

2

FP001

12

103306

1

114495

6

119656

5

D2651-1

Manufactured

No

230

Each

173.0000

22

22

D2651-1

Plug

**

15/03/14

Location

Loc Qty

Loc Code

FP001

173

112725

117

114496

56

822

Thursday, January 22, 2015 10:25:47 AM

Shop Packet Print

Page 4

Picklist Print

Page 5

Thursday, January 22, 2015 10:25:47 AM

Work Order ID: 128690

128690

Parent Item: D206-642-441

D206-642-441

Parent Item Name: Replacement Skidtube, High Gear with Standard Wearplates Fits LH or RH

Start Date: 1/26/15

Required Date: 1/30/15

Start Qty: 1.00

Required Qty: 1.00

D2651-3 Manufactured No 230 Each 758.0000 22 22

D2651-3

O-Ring

91 15/03/16

Location

Loc Qty

Loc Code

FP001

758

113577

16

120110

742

x22

D3537-1

Manufactured No

230 Each

43.0000

6

6

D3537-1

Wearpad

91 15/03/16

Location

Loc Qty

Loc Code

FG

18

79833

8

88562

10

FP001

25

126306

4

126307

21

B129514

x6

D3537-3

Manufactured No

230 Each

43.0000

1

1

D3537-3

Wearpad

91 15/03/16

Location

Loc Qty

Loc Code

FG

8

86237

8

FP001

35

120646

35

x1

Picklist Print

Thursday, January 22, 2015 10:25:49 AM

Page 6

Work Order ID: 128690

128690

Parent Item: D206-642-441

D206-642-441

Parent Item Name: Replacement Skidtube, High Gear with Standard Wearplates Fits LH or RH

Start Date: 1/26/15

Required Date: 1/30/15

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

Purchased

No

230

Each

1,400.000

2

2

MS27039-1-08

Screw

HL 15/03/15

Location

Loc Qty

Loc Code

CA

96

m128636

96

FP001

516

m128636

516

GA

2

125654

2

ST285

786

m128636

786

X2

MS27039-4-06

Purchased

No

230

Each

39.0000

1

1

MS27039-4-06

Screw

HL 15/03/15

Location

Loc Qty

Loc Code

FP001

7

m126534

7

ST283

32

m126534

32

VI

MS27039C1-08

Purchased

No

230

Each

1,170.000

60

60

MS27039C1-08

SCREW

HL 15/03/16

Location

Loc Qty

Loc Code

ST273A

731

m128650

731

ST283

439

m128650

439

M126284

→

X6

X54

Thursday, January 22, 2015 10:25:49 AM

Shop Packet Print

Page 6

Picklist Print

Page 7

Thursday, January 22, 2015 10:25:49 AM

Work Order ID: 128690

128690

Parent Item: D206-642-441

D206-642-441

Parent Item Name: Replacement Skidtube, High Gear with Standard Wearplates Fits LH or RH

Start Date: 1/26/15

Required Date: 1/30/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

230

Each

3,069.000

60

60

NAS1149C0332R

all 15/03/15

WASHER

Location

Loc Qty

Loc Code

FP001

2182

M131618

v60

m130325

2182

GA

26

125654

26

ST271

861

m130466

861

NAS1149D0332J

Purchased

No

230

Each

1,831.000

2

2

NAS1149D0332J

all 15/03/16

Washer

Location

Loc Qty

Loc Code

CA

14

m129682

14

FP001

17

m130325

17

x2

ST269

1800

m130325

1800

Thursday, January 22, 2015 10:25:50 AM

Shop Packet Print

Page 7

Picklist Print

Page 8

Thursday, January 22, 2015 10:25:50 AM

Work Order ID: 128690

128690

Parent Item: D206-642-441

D206-642-441

Parent Item Name: Replacement Skidtube, High Gear with Standard Wearplates Fits LH or RH

Start Date: 1/26/15

Required Date: 1/30/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

230

Each

5,041.000

1

1

NAS1149D0463.J

ll 15103/16

WASHER

Location

Loc Qty

Loc Code

CA
M129682

397
397

11131624

41

GA
M129390

408
408

ST260a

1167

16941
M129390

14
1153

ST269

3069

M129390
M130799

12
3057

Thursday, January 22, 2015 10:25:50 AM

Shop Packet Print

Page 8

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

F

NOTES:

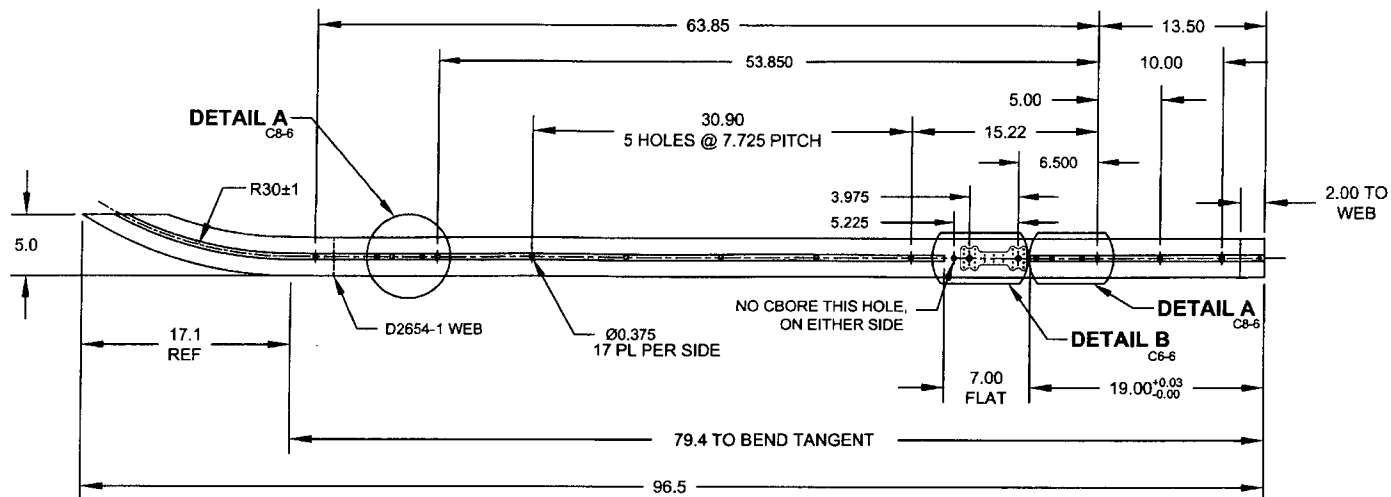
- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DEO ATTACHED

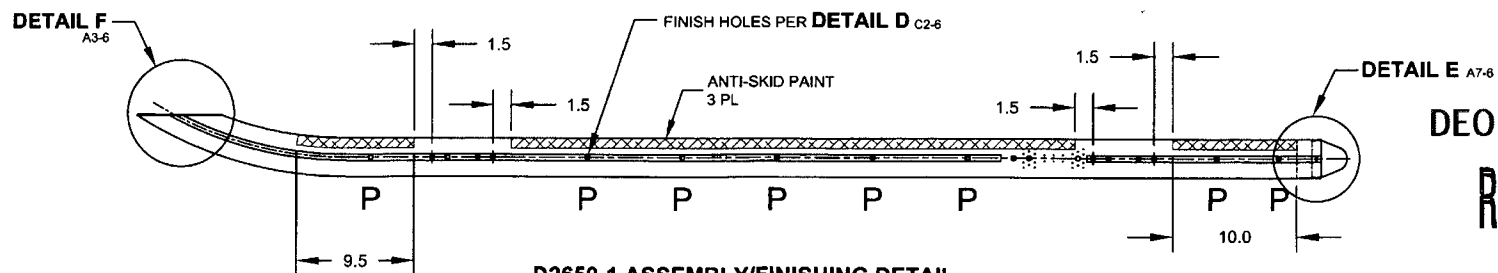
RELEASED
08-07-23

151-22
128600

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL. ADD CHAMFER	CP	06.03.30
D	REDRAW; INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



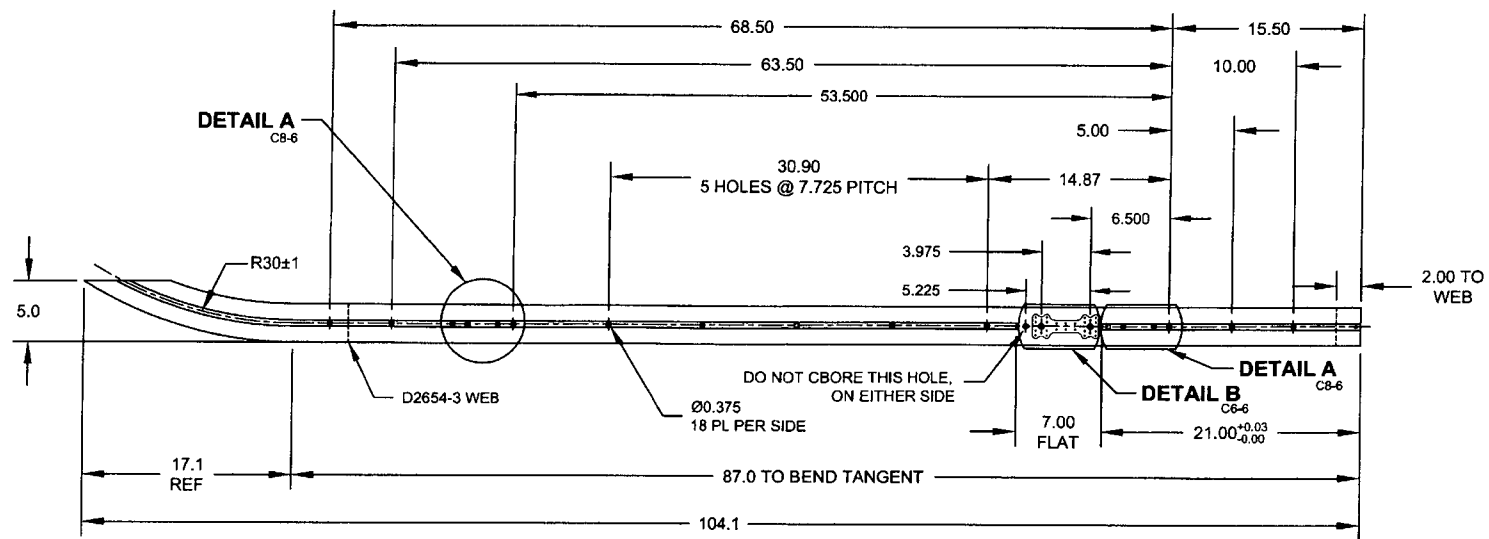
D2650-1 BENDING/DRILLING DETAIL



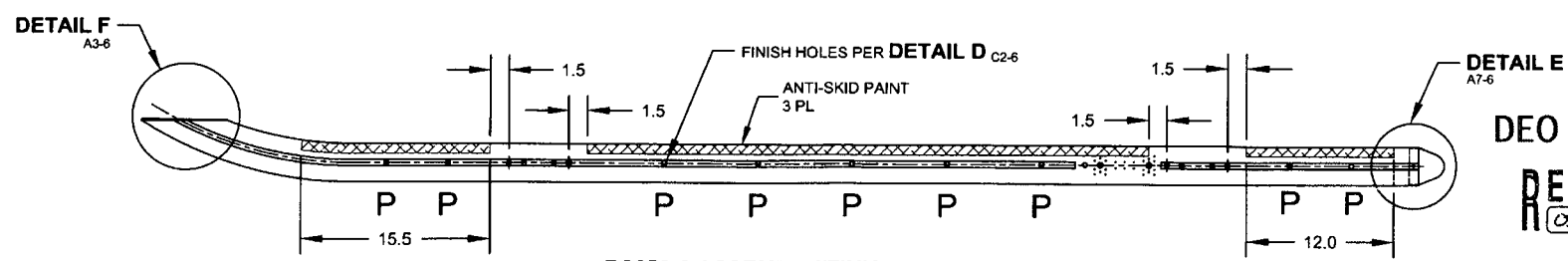
D2650-1 ASSEMBLY/FINISHING DETAIL

DEO ATTACHED
RELEASED
680922/145

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1987 BY DART AEROSPACE USA, INC	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			



D2650-3 BENDING/DRILLING DETAIL



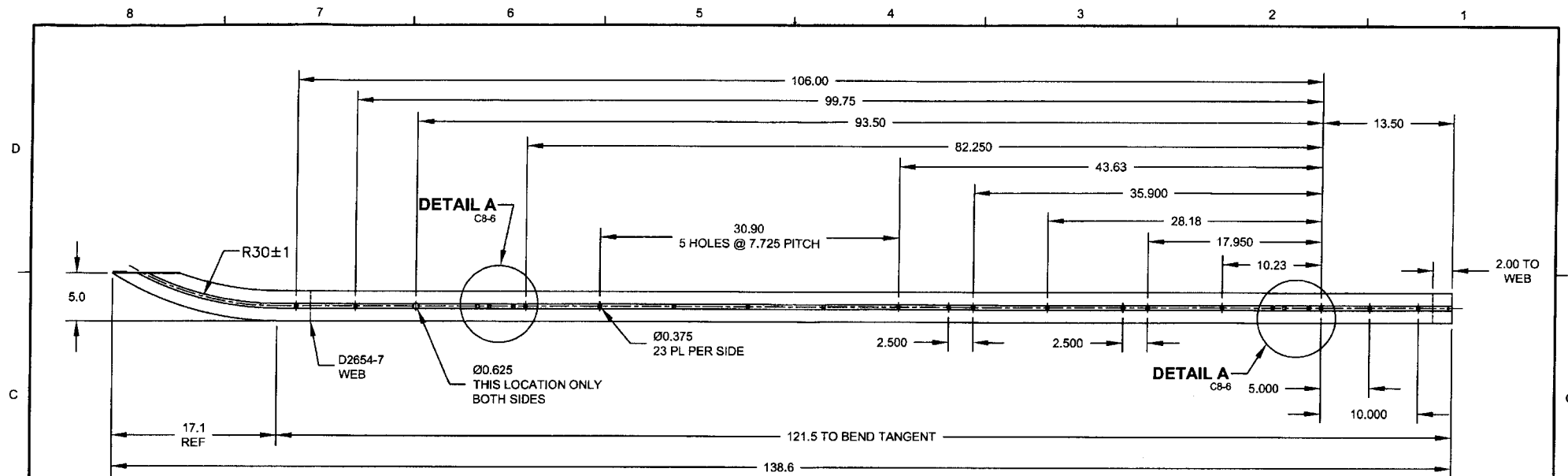
D2650-3 ASSEMBLY/FINISHING DETAIL

DEO ATTACHED
RELEASED
08-07-2-111

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



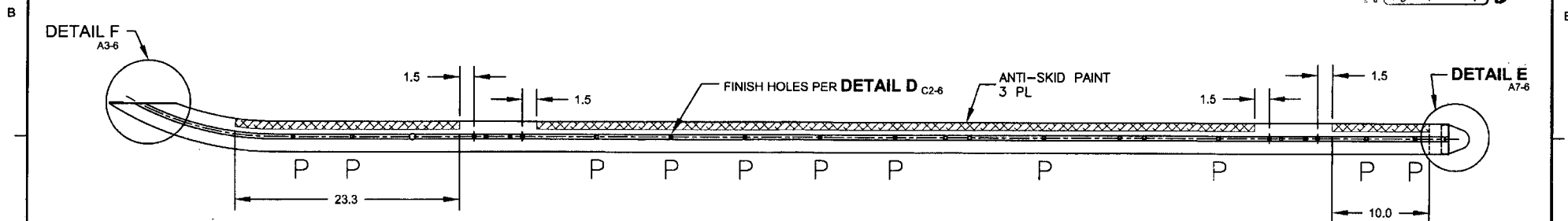
COPYRIGHT © 1997 BY DART AEROSPACE USA, INC
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE USA, INC



D2650-7 BENDING/DRILL DETAIL

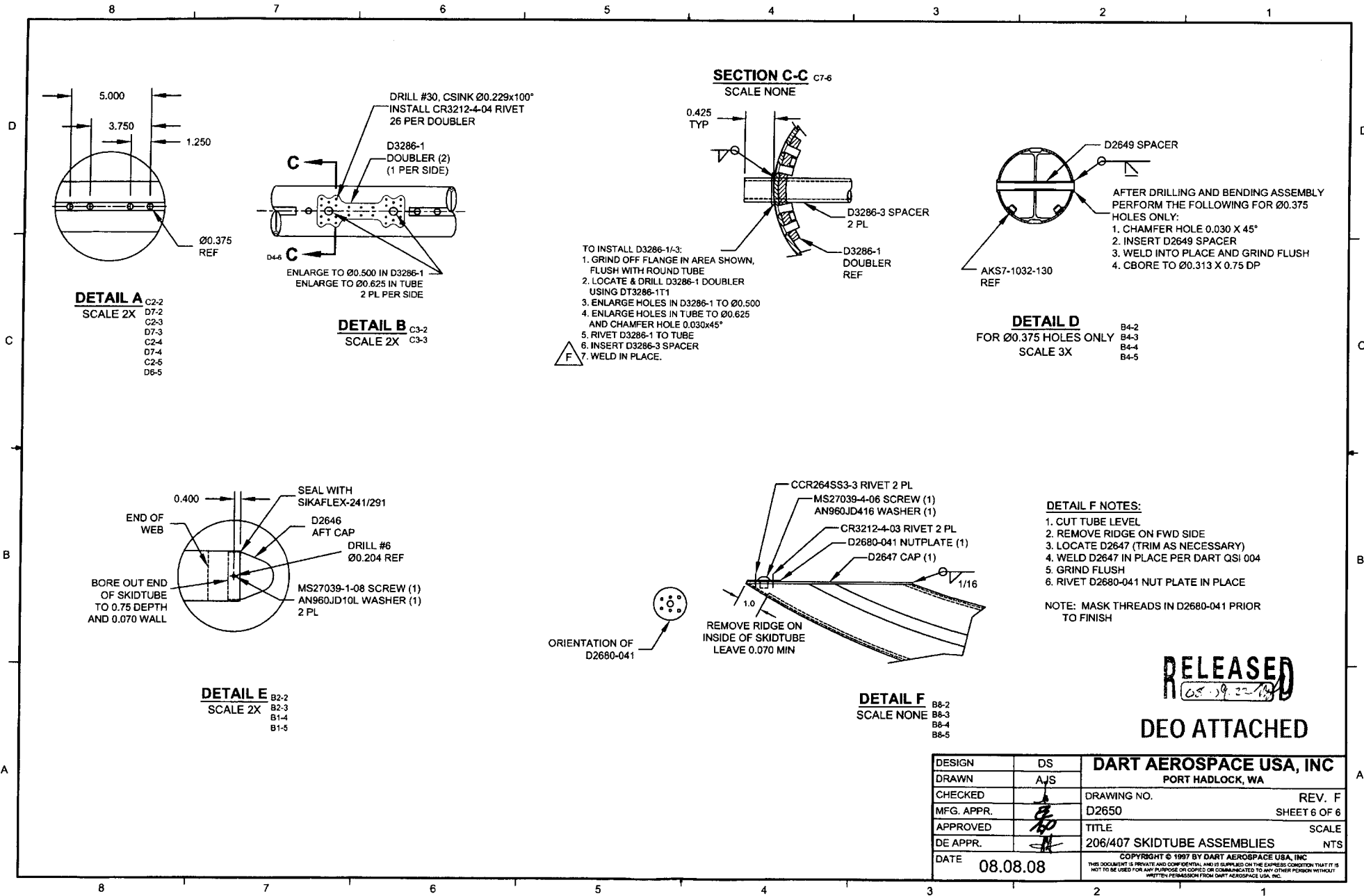
DEO ATTACHED

RELEASE
04 07-22



D2650-7 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D2650	SHEET 5 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



DRAWING NO. D2650	TITLE 206/407 SKIDTUBE ASSEMBLIES	REV. F	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2650-F-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>JP</i>	CHECKED <i>A.P.</i>	MFG. APPR. <i>AA</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 12.10.12	DATE 12.10.22	DATE 12.10.22	DATE 12.10.22		DATE 12.10.22		

PURPOSE:

CHANGE C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

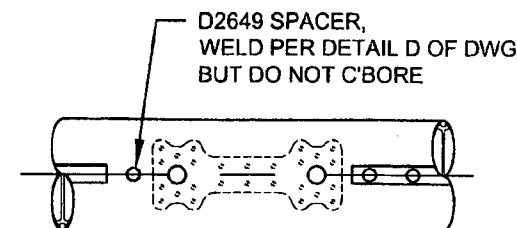
IS:

QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
-1	-3	-5	-7		
1	1	0	0	D2649	CROSS BOLT SPACER
16	17	19	23	D4720-1	SPACER

WAS:

17	18	19	23	D2649	CROSS BOLT SPACER
----	----	----	----	-------	-------------------

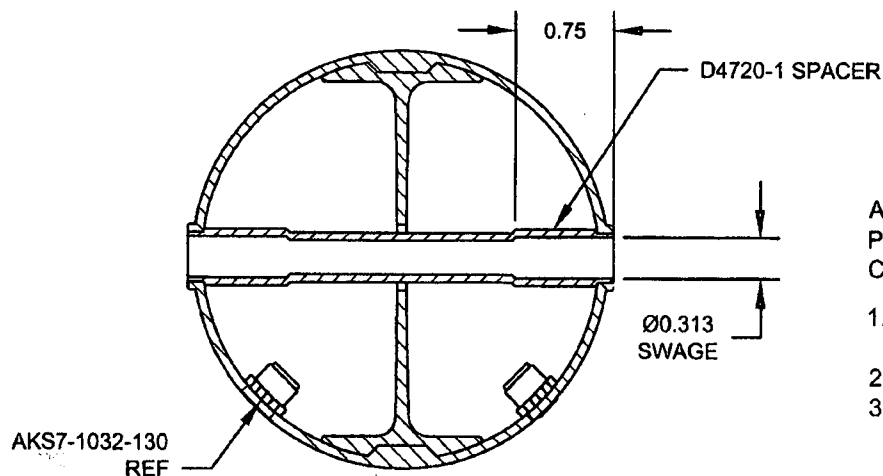
ADD DETAIL G BELOW, WHICH IS THE SAME SECTION VIEW AS DETAIL D OF DWG.
C'BORED HOLES ARE **NOW SWAGED** PER DETAIL G BELOW. FOR THE Ø0.375 HOLE THAT IS NOT C'BORED, WELD PER DETAIL D OF DWG (SEE AMENDED DETAIL B FOR REFERENCE).



DETAIL B

AMENDMENT TO DETAIL B
NOT TO SCALE

RELEASED
2012-11-16
[Signature]



DETAIL G

FOR Ø0.375 HOLES ONLY
FOR HOLES THAT ARE CURRENTLY C'BORED ONLY
NOT TO SCALE

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES THAT ARE
CURRENTLY C'BORED:

1. INSERT D4720-1 SPACER, 16 PL (-1) OR 17 PL (-3)
OR 19 PL (-5) OR 23 PL (-7)
2. SWAGE TO Ø0.313 X 0.75 DP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002